



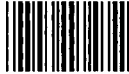






Green

Date: Wednesday, 22/10/2008 11:47:14 AM
 User: Julie Dawson



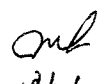
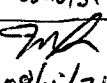
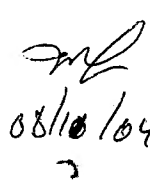
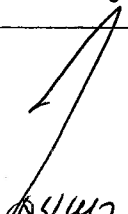
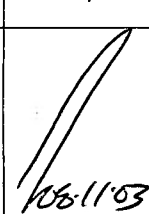
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 42802		
Estimate Number	: 10530		
P.O. Number	:	Part Number	: D2571
This Issue	: 22/10/2008 S.O. No. :	Drawing Number	: D2571 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	:
Previous Run	: 35915	Material	:
Written By	:	Due Date	: 06/01/2009 Qty: 12 Um: Each
Checked & Approved By	: <u>2008.10.22</u>		
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	Saddle Billet	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: <u>B41961</u> <u>mk 08/10/27</u>			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>42802</u> Double check by: <u>mm</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. <u>SL/mk 08/10/30</u> (12)			
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
			
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572 <u>mk/SL 08/10/30</u> (12)			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SL/mk 08/10/30</u> (12)			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2571 PAR #: N/A Fault Category: Red - NCH NCR: Yes No DQA: H Date: 08.11.13
(D412-742-011/-013) QA: N/C Closed: H Date: 08/11/20
(D205-634)

NCR: <u>42802</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/10/20	2.0	1 part scrap have a mark on the skid tube pattern. R.C. the face mill lifted the part, while the operator left for the evening. PROCESS.		SCRAP. TOO DEEP.  Replace Qty 1 - same B#	 08/10/31  08/10/31	 08/10/04		 08.11.03

NOTE: Date & initial all entries

Date: Wednesday, 22/10/2008 11:47:14 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 42802

Part Number: D2571

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

88 08/11/06

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/11/07 (12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder **SANDTEX GREEN**
(Ref: 4.3.5.1) as per QSI 005 4.3

M102316

M-F 08/11/10 (12X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-11-11 (12X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

08/11/10 (12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/12

Job Completion



MF 08-11-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 42802
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.000	8.000	8.000		
F	0.490	0.510		.503	.501	.490	.508		
G	0.257	0.262		.260	.259	.259	.259		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.498	.501	.498	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.566	.567	.566	.565		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.494	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.874	3.874	3.874		
P	0.115	0.135		.131	.129	.129	.129		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.254	.255	.255	.255		
S	0.115	0.135		.132	.127	.130	.131		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.958	2.960	2.960	2.960		
V	0.230	0.250		.242	.242	.243	.243		
W	0.115	0.135		.129	.126	.125	.126		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.365	.366	.365	.368		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.627	.627	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.252	.251	.250	.250		
AE	1.375	1.395		1.390	1.390	1.390	1.390		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.255	.255	.255	.255		
AH	0.240	0.260		.253	.253	.253	.250		
AI	2.000	2.020		2.004	2.005	2.005	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>me / J.L.</i>
Date: 08/16/27 / 08/16/28

Audited by: <i>SP</i>
Date: 08/11/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 42802	
Description: Saddle, Fwd Outboard		Part Number: D2571	
Inspection Dwg: D2571 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.001	8.000	8.001		
F	0.490	0.510		.500	.501	.502	.503		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.499	.501	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.564	.564	.566	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.129	.129	.129	.129		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.254	.254	.250	.251		
S	0.115	0.135		.129	.129	.132	.131		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.242	.243	.243	.243		
W	0.115	0.135		.126	.127	.124	.127		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.368	.367	.365	.369		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.627	.627	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.248	.245		
AE	1.375	1.395		1.390	1.390	1.390	1.390		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.255	.255	.255	.255		
AH	0.240	0.260		.253	.253	.250	.248		
AI	2.000	2.020		2.005	2.005	2.004	2.005		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: 51
Date: 08/10/29

Audited by: 88
Date: 08/11/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 42802
Description: Saddle, Fwd Outboard		Part Number: D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:






				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.003	8.006	8.002		
F	0.490	0.510		.507	.503	.502	.502		
G	0.257	0.262		.260	.260	.259	.260		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.496	.497	.499	.499		
J	1.174	1.184		1.179	1.179	1.179	1.178		
K	0.558	0.578		.562	.564	.565	.567		
L	1.174	1.184		1.179	1.179	1.179	1.178		
M	1.490	1.500		1.495	1.495	1.495	1.493		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.872	3.872	3.871		
P	0.115	0.135		.131	.131	.131	.132		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.245	.251	.251		
S	0.115	0.135		.131	.132	.132	.132		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.958	2.958	2.958	2.958		
V	0.230	0.250		.247	.237	.241	.241		
W	0.115	0.135		.130	.129	.129	.127		
X	0.308	0.313		.311	.310	.311	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.366	.366	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.635	.635	.635	.635		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.247	.245	.246		
AE	1.375	1.395		1.370	1.388	1.389	1.389		
AF	0.115	0.135		.130	.130	.130	.130		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.247	.241	.242	.247		
AI	2.000	2.020		2.005	2.002	2.004	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

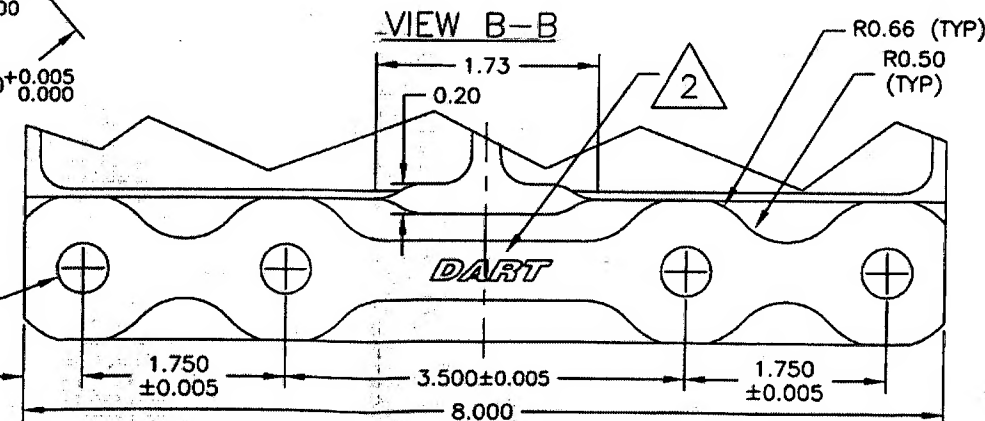
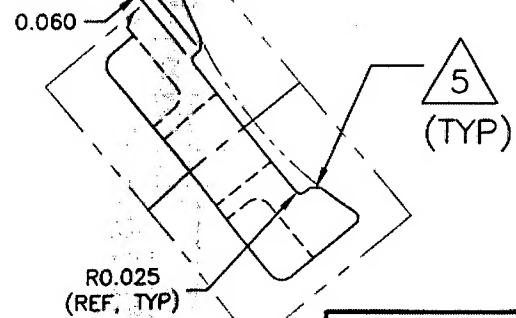
Measured by: <i>me</i>	Audited by: <i>88</i>
Date: 08/10/30	Date: 8/10/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>




05.12.06

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063" x 45° ALL AROUND |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C) |



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN DS	DRAWN BY PH	 DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2571	REV. E SHEET 1 OF 1
DATE 05.07.13		TITLE OUTER FWD SADDLE	SCALE UNC 225

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DETAIL C
SCALE 4:3

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WITHOUT NOTICE
WORK ORDER
42802

